

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021741**Date Inspected:** 01-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Goodwin Steel, UK**Location:** Trentham, UK

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	Cable band				

Summary of Items Observed:

The following report is based on METS observations at Trentham UK on this date:

The QA Inspector met with Goodwin International personnel Me. Chris Ryder. The QA inspector received a shipper for the cable band assemblies listed below shipping to South Staffs for further processing. This QA inspector reviewed copies of the Completed partial documentation packages for the Cable Band Assemblies being shipped to South Staffs. The documents contained the following: Material test reports, nondestructive testing reports, and Certificates of compliance from Goodwin Steel Foundry. The material appeared to be in conformance with the contract documents with the following exceptions noted below:

- a. East Panel Point 34. The following apply ABF-RFI-2353R0 for the male casting.
- b. West Panel Point 36. The following apply ABF-RFI-2350R0 for the male and female castings.
- c. East Panel Point 38. The following apply ABF-RFI-2355R0 for the male and female castings.
- d. West Panel Point 48. The following apply ABF-2349R0 for the male casting, and ABF-RFI-2271R0 for the male and female castings.

The cable band assemblies were released via a Green tag with Blue Dot to South Staffs for further processing.

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The QA Inspector observed welding of Casting GG29434-2, Drawing Number 5540-B8-2-M. The welding was being performed by Mr. B. Whyte. Mr. Whyte was using WPS04-102F4B Issue 5. The welding was being performed at 112 amps. The filler metal was 3.2mm AWS A5.1 E 7018-1. Welding was being performed in the 3G position.

The QA Inspector observed that the finished cable bands for East Panel Point 18, East Panel Point 20, East Panel Point 52, West Panel Point 16, West Panel Point 24, West Panel Point 70, and West Panel Point 76 were loaded into a container to be shipped to site. Photographs are included with this report.

The QA Inspector observed Casting 5540-B10-2-M(4) at finish grinding. The weld repairs are being ground to final finish condition. This is being completed by Goodwin International Personnel.

The QA inspector reviewed a copy of the Goodwin Steel Castings “Weld Excavation Map” for casting GG29427-1(R7), B6-1-F. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This eighth repair cycle is a minor repair and does not require post weld heat treatment. Caltrans Lot Number B243-062-11 was assigned for tracking purposes.



Loading container for shipment to job site



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Riegler,Randy

Quality Assurance Inspector

Reviewed By: Edmondson,Fred

QA Reviewer